

Work Order ID 123809

August-25-14 12:38:14 PM

123809

~~PRELIMINARY ISSUE~~ Page 1

Item ID: D5124-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 8/25/14

Start Qty: 6.00

6

Cust Item ID:



Required Date: 8/25/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

d5124

~~Prelim~~ *AS* *Rev A* *J.J.*

100

HAAS CNC VERTICAL MACHINING #1

0.00

100

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FB340

Folio Rev: *AA*

Dwg Rev: *A*

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
20
9-89

14-09-07

DAS
20
9-89

14-09-07

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Item ID: D5124-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 8/25/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/25/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>LG53</u>	0.00							DAS 41 9-89
130									
Packaging	Memo	0.00							
Packaging									14-9-11
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 14-08-25 AUTH [Signature]

RELEASED [Signature] DATE [Signature]

N/A [Signature]

Picklist Print

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Work Order ID: 123809

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Parent Item: D5124-1

D5124-1

Parent Item Name: Support

Start Date: 8/25/14

Required Date: 8/25/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A RQ verified by JLM 14/08/08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5124-1TRN

Manufactured No

Each 1.0000

6

D5124-1TRN

**

A.A 14/09/08

Support

Location

Loc Qty

Loc Code

MAT060

1

123554

1

→ 123 808

3

10.04.15

#3

[illegible]

Measured by:	20 8-89
Date:	14-09-06

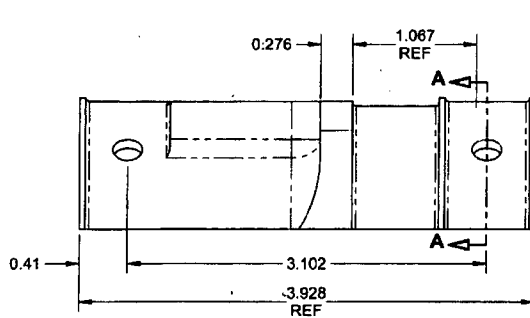
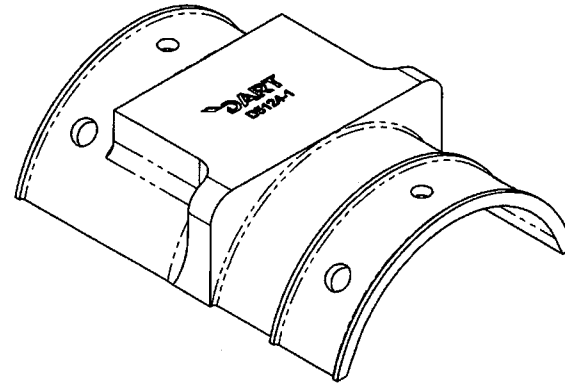
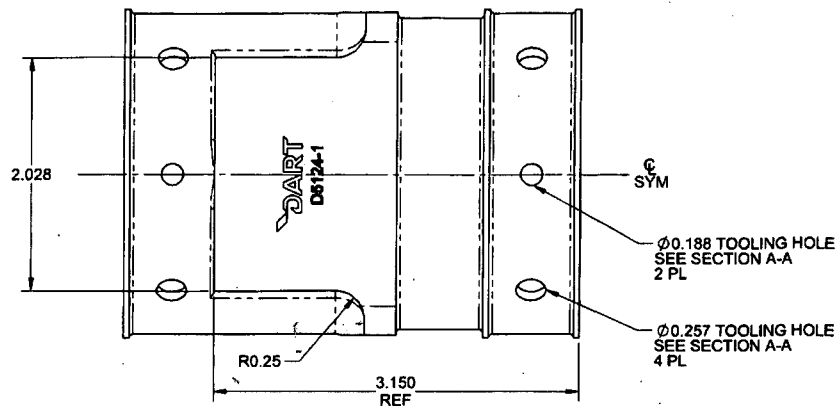
Audited by:	<i>L.A.</i>	DAS
Date:	<i>14/09/08</i>	08
		9-89

Preliminary Approval:	
Date:	

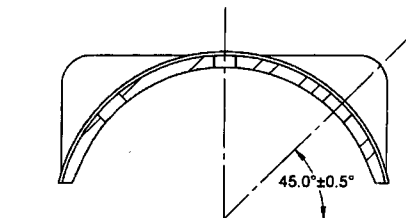
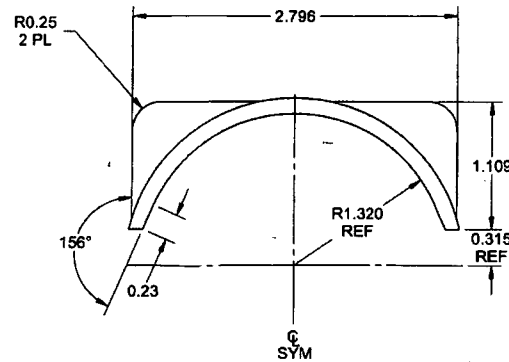
H:\FORMS\Quality Assurance\approved QA\FAI revE

10.04.15

10.04.15



D5124-1 FWD SUPPORT



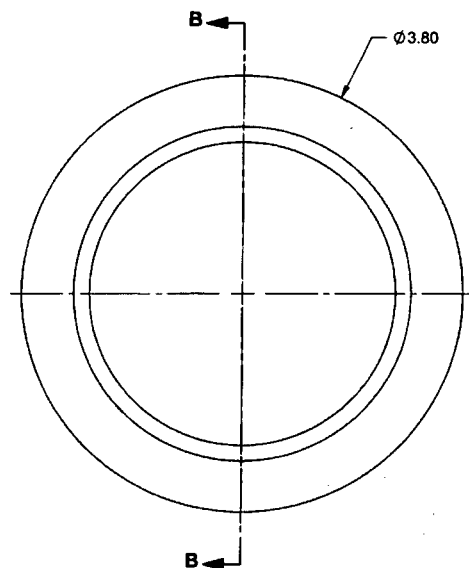
SECTION A-A

RELEASED
2014-08-25

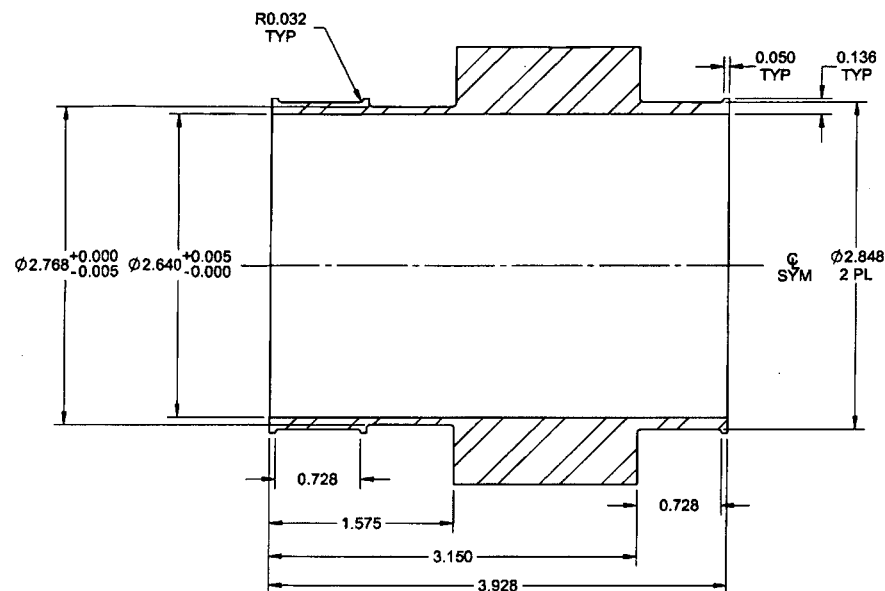
- NOTES:**
- 1) MATERIAL: MAKE FROM D5124-1TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5124-1" IN AREA SHOWN USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3, IDENTIFY WITH DART B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.54 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5124-1-REVA.SLDPRT"

A		NEW ISSUE		AP	14.08.07
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5124 TITLE FWD SUPPORT		REV. A	
DRAWN	AP			SHEET 1 OF 2	
CHECKED	CP			SCALE	
MFG. APPR.	JLM			NTS	
APPROVED	MP				
DE APPR.	DS				
DATE	14.08.07				

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D5124-1TRN FWD SUPPORT



SECTION B-B

RELEASED
2014-08-25
MP

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.14 lbs

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5124	SHEET 2 OF 2
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DE	FWD SUPPORT	NTS
DATE		14.08.07	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DQA:

Date:

14/09/18

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

14/9/15

Work Order update only ☐

Work Order: <u>123809</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>05124-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4214</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.09.08	100	2	DIM "1.067 REF" IS NOT GOING TO ANYTHING. DIM 2.796 IS 2.756 (2.756) ON BOTH PARTS → Re Program SWM/	A.P. 14.09.08	ACCEPTABLE NOT CRITICAL, NO EFFECT ON STRENGTH. Adjust program	A.P. 14.09.08	DAS 20 9-89 14-09-08	S 14/09/08
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input checked="" type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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